Work Order Tuesday, March 0				*980	140*							Page 1
Revision ID:	D2232-3 Basket Hinge		A	Accept	*N900	<u>040</u>	100)* s	etup S	Start Stop	*N: *N:	S1* S2*
Start Date: 3 Required Date: 3 Reference:	s/4/2013 s/25/2013	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item Customer:	ID:						
Approvals:	Process Pla	n:	Date:/3-03-5	Tooling: SPC (Y/N):		ate:	-	R		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D2232	Rev	C										
*100		FLOW WATER JET		0.00				24	, 0			Jm13.3-1
Waterjet FLOW CNC Waterjet 304.125		Memo 1-Cut as per Deburr if ne	Dwg D2232 Dwg Rev:cessary	0.00 Prog Rev:	<u>-</u> 2-							
*110		QC2- Inspect parts off m	achine FAI/FAIB	0.00				24				7 33 1
QC Quality Control		Мето		0.00				6-7				Jm 13-3-16
120		QC8- Inspect parts - seco	and check	0.00			(u As				ن مبد
120 QC Quality Control		Memo		0.00	13/07/18			(x24)			***

NCR: Ye	es / No				WORK ORDER NON-C	ONFOR	MANCE / UPI	DATE	•		
									QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·
Work Order	·:				DISPOSITION			AGAINST DE	PARTMENT,	PROCESS Water Jet] Faringsvins
Part No.			Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing	Į.	d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR No	0				Work Order Update		Large Fab	Composite	<u> </u>	Supplier	
Root	Description of work order update				Initial	Act	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling		:									
Operator										i	
Material							i i				
Setup		ļ									
Other											
Process											
Supplier											
Training											
Unapproved											
					F	AULT CAT	EGORY			· · · · · · · · · · · · · · · · · · ·	
Landin	g Gear				General			٠.	-		_
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instru	tions Incomplete/	Unclear .	Part Lost/M	issing	Wrong Stock Pulled
Γ	Cuffs		Contamination	Maint	enance		Part Moved		_		
	Heat Treat			Countersink	Mislab	eled		Positioned \	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	ad		Power Loss/	'Surge	Other
⊨ ' ' ' ⊢ '			Drill Holes	Offset				_			
<u> </u>				Drawing	Out of	Calibration					
<u> </u>	—		Finish	Out of	Sequence						
	Wave/Twist in Tube				Folio	Outsic	le Dimensions				

DQA:

Date:

Quality Control

el 30320

NCR:	: Yes	/ No

DQA: _____ Date: ____

NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			: 1	
									QA Closed:	Date	:	
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			· · · · · · · · · · · · · · · · · · ·		Rework		Skid-tube	Crosstube]	Water Jet	Engineering	
Part No.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
			•		Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier		
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process							ļ					
Supplier												
Training												
Unapproved					•		L _i .					
					F/	AULT CATE	GORY					
Landin	ng Gear			_	General			_	7	_	<u> </u>	
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced	
1	Centre No	ot Concer	ntric to (D/S	BOM/Route	Hardw		_	Over/Under	tolerance	Temperature/Cure	
1	Cracks				Broken/Damaged	-	tion Incomplete		Part Incorre	<u> </u>	Weld	
1	Crushed/Crimped.				Burrs	\vdash	tions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	⊢ ⊢	enance	<u> </u>	Part Moved			
Heat Treat			Countersink	Mislab			Positioned \	· -	_			
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other	
Ripples in Bend Drill Holes			Offset				<u> </u>					
Į	Torque Waves in Extrusion Drawing			Drawing	Out of	Calibration						
	Turning Sequence Finish			4	Out of	Sequence						
	Wave/Twist in Tube			1	Folio	Outsid	Outside Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

5 Tuesday, March 05, 2013 1:42:11 PM

Work Order ID: 98040

98040

Parent Item:

D2232-3

D2232-3

Parent Item Name:

Basket Hinge

Start Date: 3/4/2013

Required Date: 3/25/2013

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B01.06.07Now laser cutEC

IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	264.6500	0.0694	L461053			
M304S11	GA								**	1,5			JM13-3-16

304/316 0.125 Sheet

Location	Loc Qty	Loc Code	
MAT020	264.65		
122521	72.65		132531
24445	192		

NCR:	Yes	/	No

WORK ODDED NON-CONFORMANCE / HIDDATE

DQA: _____ Date: ____

NCK: Y	es / No				WORK ORDER NON-C	ONFORI	VIAIVEL / OFL		QA Closed:	Date	:	
Work Orde	or.				DISPOSITION			AGAINST DE	DEPARTMENT/PROCESS			
Part No.			Rework Scrap	ì 1	Skid-tube Crosstube Machining Small Fab		ľ	Water Jet	Engineering Quality Other			
NCR No.				Use-as-is Work Order Update			Finishing Composite	Rec/Stor	e/Packaging Supplier _	- Other		
Root				Descri	ption of work order update	Initial	Acti	ion	Sign &			
Cause	Daté	Step	Qty	(or Non-conformance	Chief Eng	Descr	iption	Date	Verification	QC Inspector	
Doc/Data								:		II.		
Equip/Tooling								•				
Operator											·	
Material			,									
Setup	_	1								į		
Other												
Process												
Supplier												
Training												
Unapproved						L AULT CATE	CORV		<u> </u>	l		
l andi:					General	AULI CATE	GURT					
Landi	ng Gear Bending				Bend	Grain			Ovalized	Г	Pressure/Forced	
	Centre No	ot Conco	ntric to ()/s	BOM/Route	Hardwa	are	<u> </u>	Over/Under	tolerance	Temperature/Cure	
	Cracks	or conce	initiae to t	^{5/3} -	Broken/Damaged	\vdash	ion Incomplete	ļ	Part Incorre	<u></u> -	Weld	
ł		Crimned			Burrs	—	tions Incomplete/U	Inclear	Part Lost/M	⊢	Wrong Stock Pulled	
ļ	Crushed/Crimped. Cuffs			-	Contamination		enance		Part Moved			
Heat Treat			Countersink	Mislabe			Positioned V	Vrong				
Inspection Strip in Tube			Cut Too Short	Misrea			Power Loss/		Other			
	Ripples in		/		Drill Holes	Offset		L	.	~ L		
	Torque W		xtrusion	, <u> </u>	Drawing	\vdash	Calibration					
	Turning S				Finish	⊢	Out of Sequence					
ľ	Wave/Twist in Tube			Folio	$\boldsymbol{\vdash}$	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 98040
Description: Basket Hings	Part Number: 102z32-3
Inspection Dwg: D2232 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
00.257"	10006	O.258°			V	Jamos
0.500Y	11-0-000	0.506	_		V	
0. 500.	11-0.010	0.503	-		V	
2.250"	11-000	2.255	_		·V	
C). 750"	11-0-010	0350°			ν	
1.000	11-0000	1,000	-		V	
0.750'	11-0.00	0.750	-		V	
2.500"	11-0-00	2.506"	_		V	
0.125"	11.0.000	0.017"	_		ν	
:						

Measured by:	Audited by:	Preliminary Approval:
Date: (3-3-16	Date: 16 13/03/18	Date:

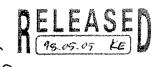
Rev	Date	Change	Revised by Approved
E	10.04.14	Added preliminary approval	KJ

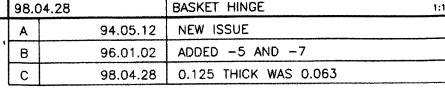
A 10.04.15



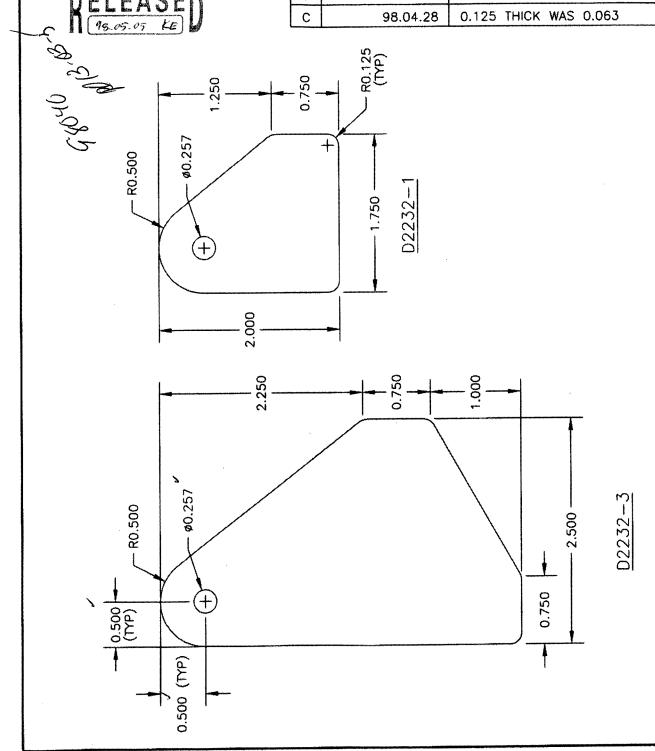


	DESIG)	DRAWN BY	DART AEROSPACE LTE HAWKESBURY, ONTARIO, CANADA)	
	CHECK	ED.	APPROVED	DRAWING NO.	REV.	С
	7		IH	D2232 SHEE	T 1 OF	2
	DATE			TITLE	SCA	LE
	98.0)4.28		BASKET HINGE		1:1
	Α	·	94.05.12	NEW ISSUE		
١			00.04.00	ADOED E AND 7		





MATERIAL: AISI 304/316 SS 0.125 THICK



R0.125 (TYP)

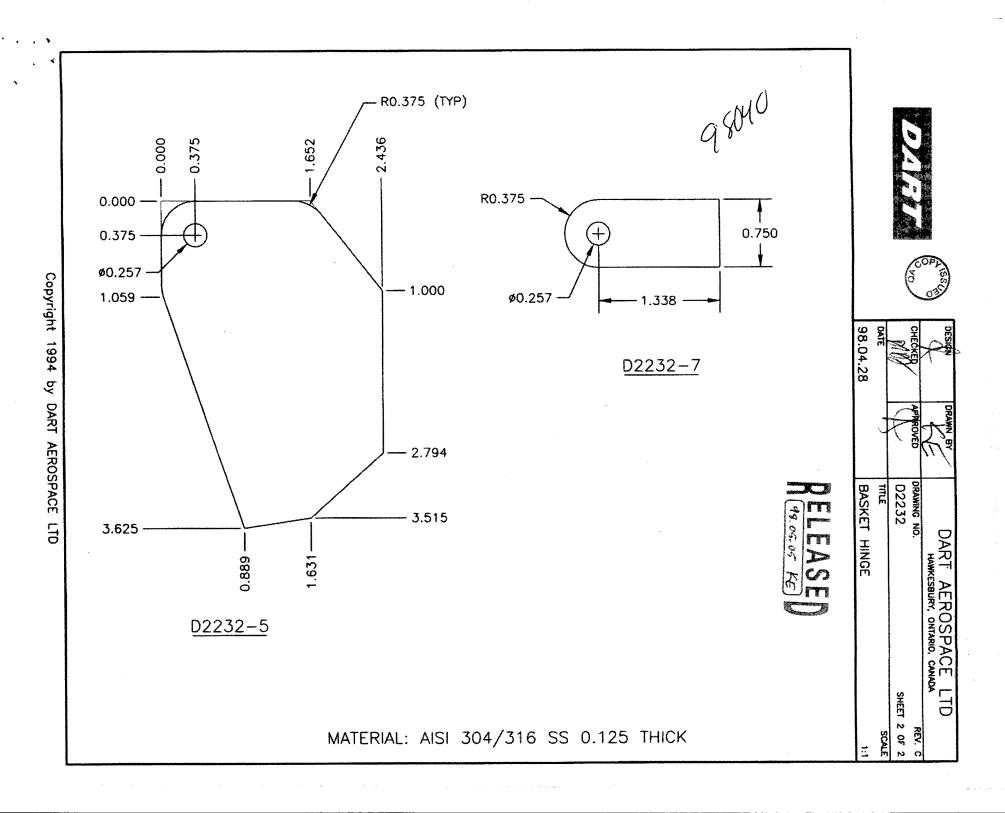
0.750

Copyright 1994 by DART AEROSPACE LTD

NCR:	Yes	/	No
		,	

Date:

NCR: Ye	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP	DATE	QA Closed:	Date	· · · · · · · · · · · · · · · · · · ·	
Work Orde					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part N					Rework Skid-tube Scrap Machining		Crosstube Small Fab	Water Jet Prod. Eng. Coor.		Engineering Quality		
NCR N	0				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stor	Other		
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty	•	or Non-conformance	Chief Eng	ef Eng Description		Date	Verification	QC Inspector	
Doc/Data												
quip/Tooling										,	,	
Operator								•				
Material											,	
Setup											•	
Other		1										
Process												
Supplier												
Training					•						:	
Unapproved												
					F.	AULT CAT	EGORY	<u> </u>				
Landin	g Gear				General				7			
L	Bending				Bend	Grain			Ovalized	L	Pressure/Forced	
L	Centre Not Concentric to O/S			o/s	BOM/Route	Hardw	are		Over/Under tolerance		Temperature/Cure	
L	Cracks				Broken/Damaged	Inspec	nspection Incomplete		Part Incorrect		Weld	
	Crushed/Crimped.				Burrs	Instru	ructions Incomplete/Unclear		Part Lost/Missing Wrong		Wrong Stock Pulled	
	Cuffs				Contamination	Maint	Maintenance			Part Moved		
	Heat Treat				Countersink		Mislabeled			Positioned Wrong		
	Inspection Strip in Tube				Cut Too Short	Misrea	lisread		Power Loss	Surge	Other	
Γ	Ripples in Bend				Drill Holes	Offset						
Ī	Torque Waves in Extrusion				Drawing	Out of	Calibration					
	Turning Sequence				Finish	Out of	Sequence					
r	Wave/Twist in Tube				Folio Outside Dimensions							



									*		DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			,	
									-		QA Closed:	Date:		
						DISPOSITION				AGAINST DE	GAINST DEPARTMENT/PROCESS			
Work Ord	er:					Rework		Skid-tube Crosstube			Water Jet		Engineering	
Part I	Nο					Scrap		Machining Small Fab			Prod. Eng. Coor.		Quality	
luiti									Thermoforming Finishing		Rec/Store/Packaging		Other	
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier		
	•													
Root						ption of work order update	1	Initial		tion	Sign &			
Cause	_	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling	Ш													
Operator	Ш					•								
Material	Ш													
Setup].											
Other	Ш													
Process							ļ							
Supplier														
Training														
Unapproved												<u> </u>		
							AUI	T CATE	GORY	•.				
Landi	ing (Gear				General	_	,		-	7		1	
		I ~ I				Bend		Grain			Ovalized		Pressure/Forced	
						BOM/Route		Hardwa	ire		Over/Under tolerance		Temperature/Cure	
						Broken/Damaged	_	-t '	ion Incomplete		Part Incorre		Weld	
	Crushed/Crimped.				Burrs	\perp	Instruct	tions Incomplete/	/Unclear	Part Lost/Missing		Wrong Stock Pulled		
	Cuffs					Contamination		Mainte	enance		Part Moved			
	Heat Treat Cou				Countersink		Mislabe	eled		Positioned \	Wrong	-		
	Inspection Strip in Tube					Cut Too Short	ort Misread				Power Loss,	/Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio